

(12) **United States Patent**
Maeda

(10) **Patent No.:** **US 9,164,495 B2**
(45) **Date of Patent:** **Oct. 20, 2015**

(54) **MOTOR CONTROLLER CONTROLLING TWO MOTORS FOR DRIVING SINGLE DRIVEN OBJECT**

(56) **References Cited**

U.S. PATENT DOCUMENTS

(71) Applicant: **FANUC Corporation, Yamanashi (JP)**

5,646,495 A * 7/1997 Toyozawa et al. 318/625
6,046,566 A * 4/2000 Sonoda et al. 318/625

(72) Inventor: **Kazuomi Maeda, Yamanashi (JP)**

FOREIGN PATENT DOCUMENTS

(73) Assignee: **FANUC CORPORATION, Yamanashi (JP)**

JP 8-16246 A 1/1996
JP 8-174481 A 7/1996
JP 2001-273037 A 10/2001
JP 2001-300792 A 10/2001
JP 2003-79180 A 3/2003
JP 2003-189657 A 7/2003
JP 2005-278362 A 10/2005
JP 2007-116836 A 5/2007
JP 2009-177881 A 8/2009
JP 2010-172054 A 8/2010
JP 2012-165610 A 8/2012
JP 2013-31234 A 2/2013
WO 2004/092859 A1 10/2004

(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

(21) Appl. No.: **14/333,606**

(22) Filed: **Jul. 17, 2014**

(65) **Prior Publication Data**

US 2015/0022137 A1 Jan. 22, 2015

(30) **Foreign Application Priority Data**

Jul. 19, 2013 (JP) 2013-150939

(51) **Int. Cl.**
G05D 23/275 (2006.01)
G05B 11/32 (2006.01)
G05B 6/02 (2006.01)
G05B 13/02 (2006.01)

(52) **U.S. Cl.**
CPC **G05B 6/02** (2013.01); **G05B 13/021** (2013.01)

(58) **Field of Classification Search**
CPC G05B 6/02; G05B 2219/41264; G05B 2219/42063; G05B 13/021; G05B 19/19; G05B 19/182
USPC 318/632, 625
See application file for complete search history.

* cited by examiner

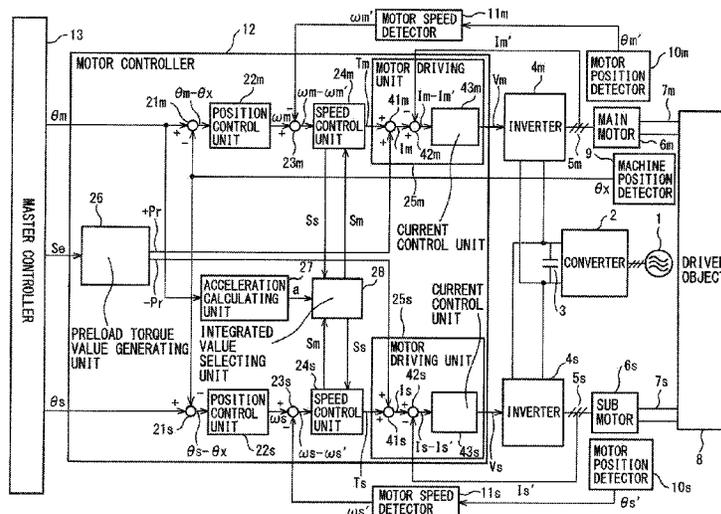
Primary Examiner — Bentsu Ro
Assistant Examiner — Zemenay Truneh

(74) *Attorney, Agent, or Firm* — Hauptman Ham, LLP

(57) **ABSTRACT**

In a motor controller according to the present invention, a speed control unit 24_m includes an integrator calculating an integrated value S_m of a speed error ω_m-ω_m' between a speed command value ω_m and a rotation speed ω_m' and generates a torque command value T_m based on ω_m-ω_m', a predetermined value, a proportional gain and an integration gain. A speed control unit 24_s includes an integrator calculating an integrated value S_s of a speed error ω_s-ω_s' between a speed command value ω_s and a rotation speed ω_s' and generates a torque command value T_s based on ω_s-ω_s', the predetermined value, a proportional gain and an integration gain. An integrated value selecting unit 28 selects any one of S_m and S_s as the predetermined value, depending on a drive status of a main motor 6_m and a sub motor 6_s.

3 Claims, 5 Drawing Sheets



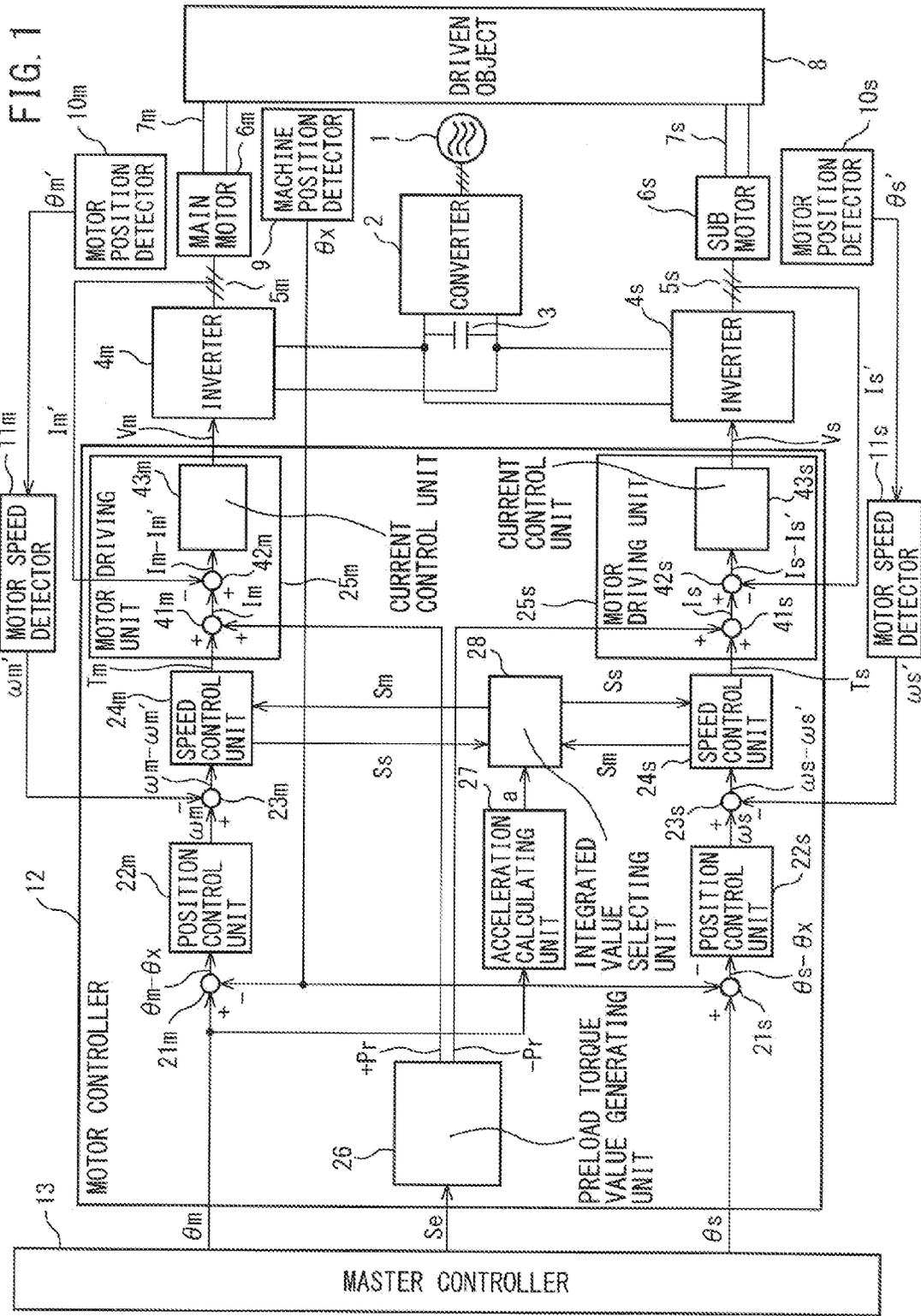


FIG. 2

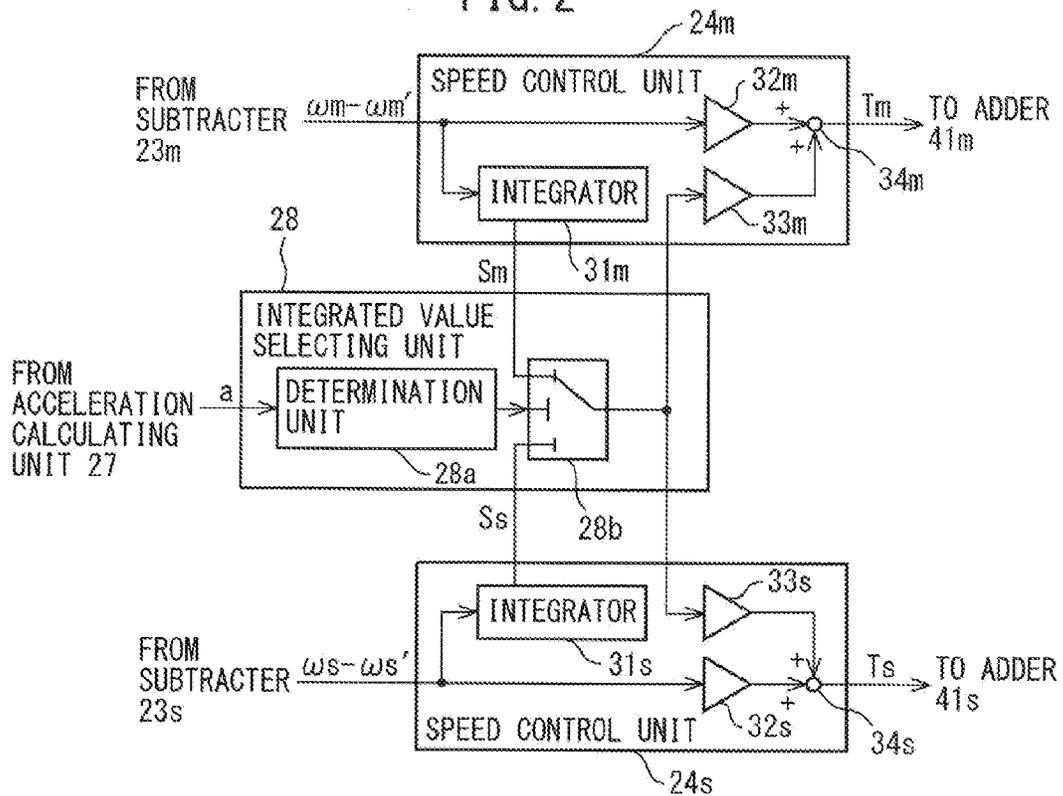


FIG. 3

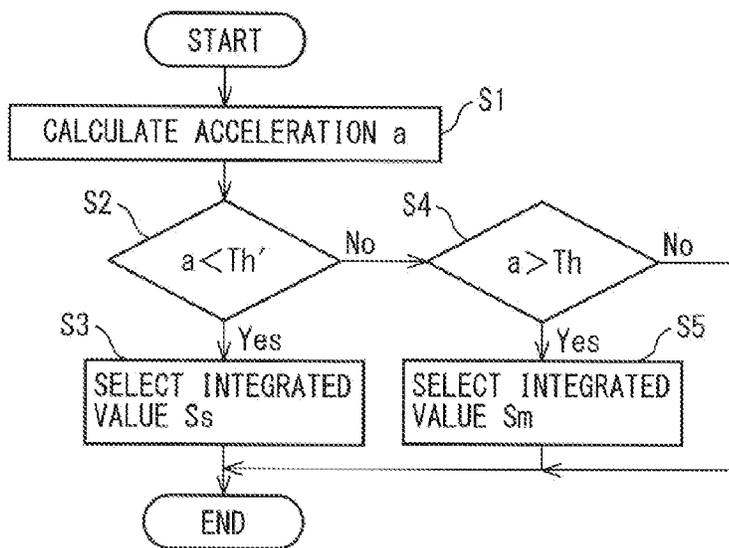


FIG. 4

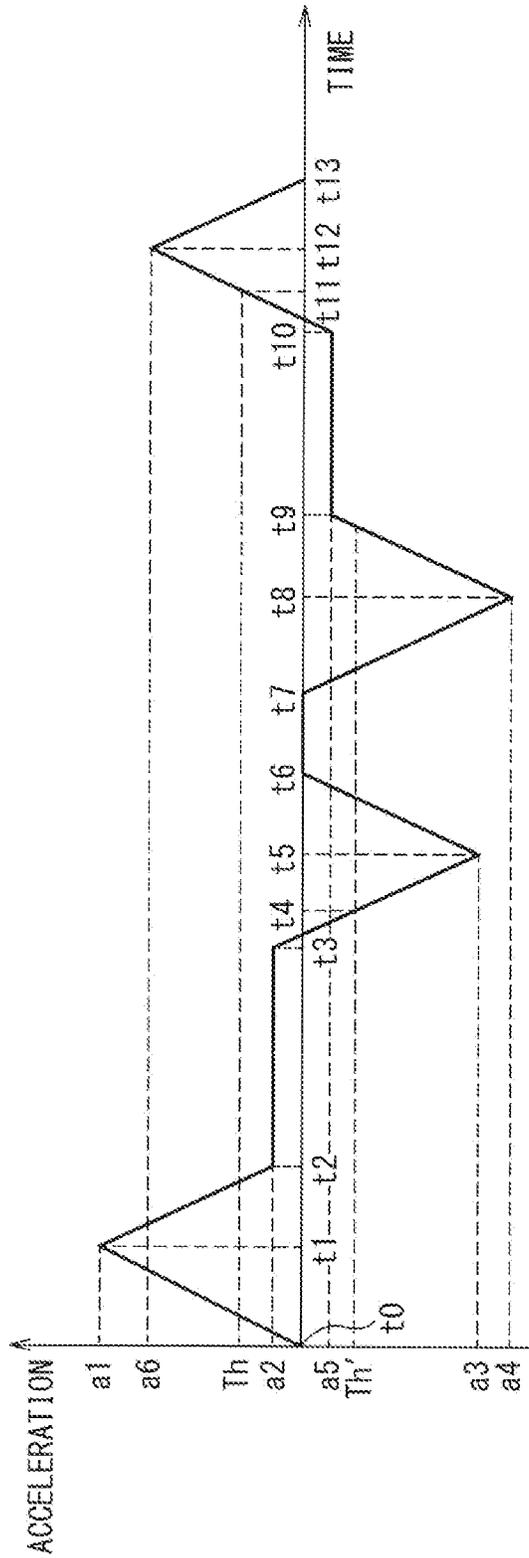


FIG. 5C

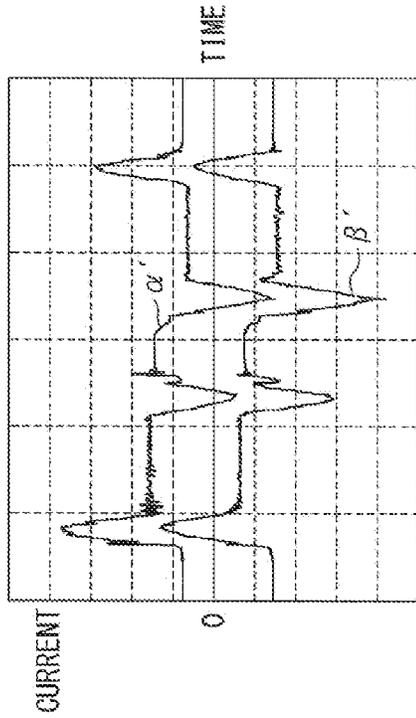


FIG. 5D

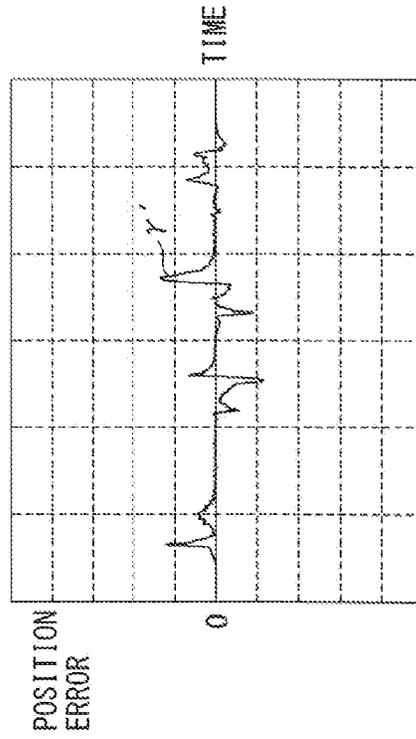


FIG. 5A

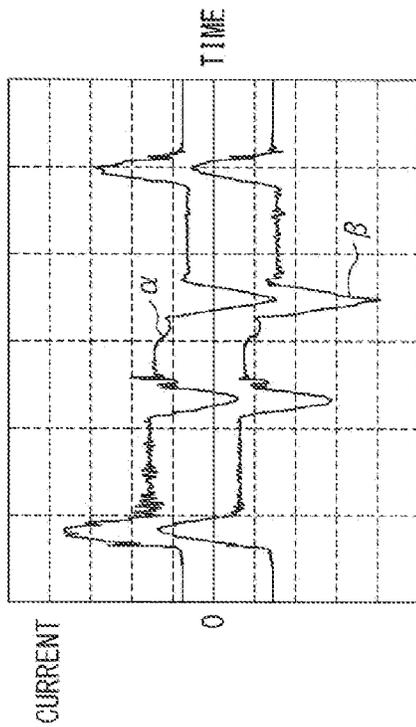


FIG. 5B

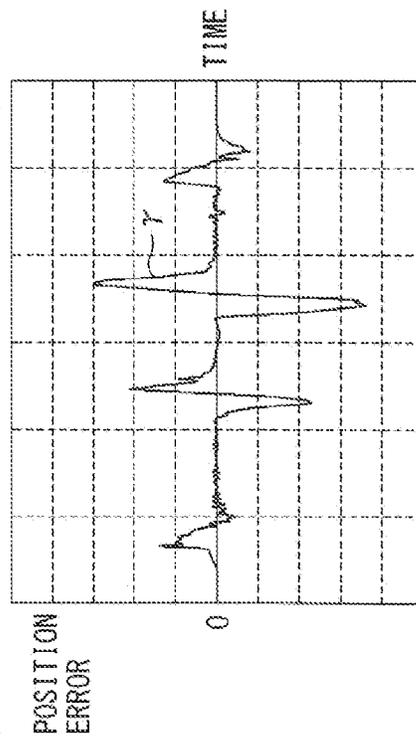
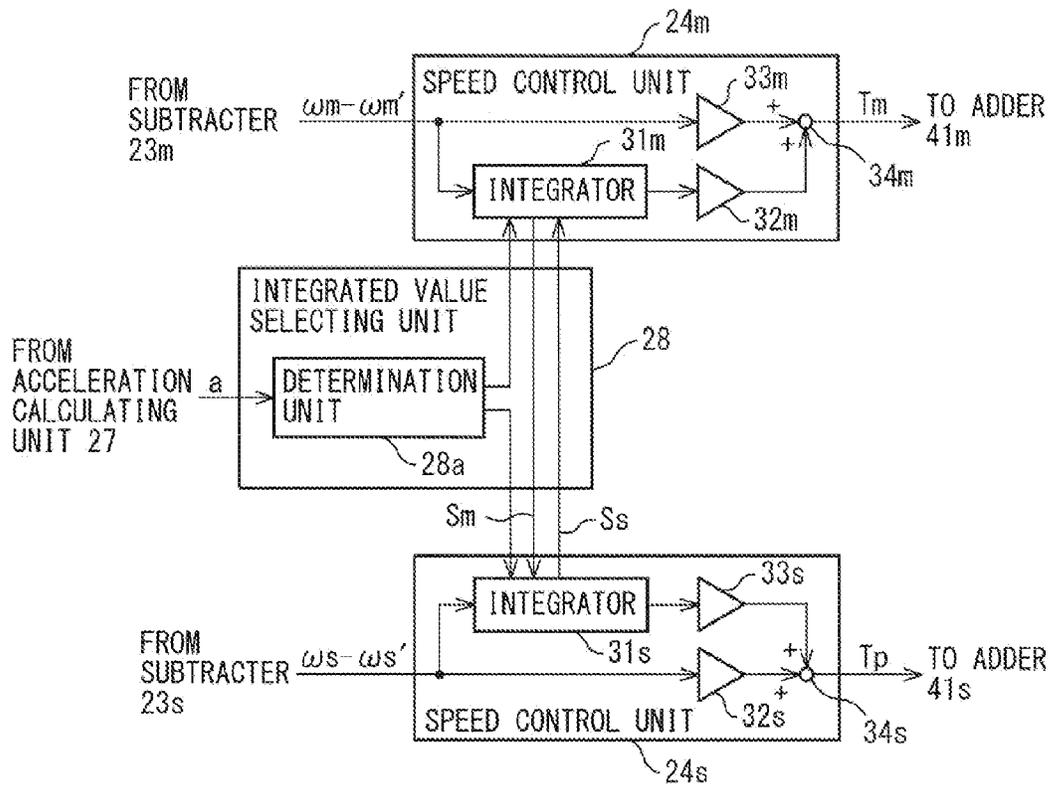


FIG. 6



1

MOTOR CONTROLLER CONTROLLING TWO MOTORS FOR DRIVING SINGLE DRIVEN OBJECT

CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a new U.S. patent application that claims benefit of JP 2013-150939, filed on Jul. 19, 2013, the entire content of JP 2013-150939 is hereby incorporated by reference.

FIELD OF THE INVENTION

The present invention relates to a motor controller controlling two motors for driving a single driven object.

BACKGROUND OF THE INVENTION

Some motor-driven objects in machine tools and the like can be so large that the driven objects cannot be accelerated and decelerated by one motor alone. Furthermore, large backlash between mechanical elements of a transmission mechanism connected to a motor drive shaft and a driven object may prevent the driven object from being stably moved. In that case, tandem control is employed in which a single driven object is driven by two motors (For example, Japanese Unexamined Patent Publications No. JP-A-8-174481, JP-A-2003-79180, JP WO2004/92859, JP-A-2009-177881).

In such tandem control, one of two motors functions as a main motor having a drive shaft that acts as a master shaft coupled to a transmission mechanism. The other motor functions as a sub motor having a drive shaft that acts as a slave shaft coupled to a transmission mechanism.

To perform tandem control, backlash between mechanical elements of the transmission mechanism connected to the drive shaft of the motor and the driven object needs to be minimized. Therefore, a motor controller has been proposed that generates a preload torque value, which is a torque value added to a torque command value beforehand such that a force applied to the drive shaft of the main motor and a force applied to the drive shaft of the sub motor are in opposite directions (For example, Japanese Unexamined Patent Publications No. JP-A-8-16246, JP-A-2001-273037).

Further, adverse effects caused by a difference between the timing of detecting the speed of the main motor and the timing of detecting the speed of the sub motor on control of the motors and the like and overheat of the motors caused by such differences in tandem control need to be avoided. Therefore, a motor controller has been proposed that uses an integrated value of speed error between a speed command value for the main motor and the speed of the main motor to generate a torque command value for the main motor and a torque command value for the sub motor (For example, Japanese Unexamined Patent Publication No. JP-A-2003-189657).

Another motor controller has been proposed that generates a preload torque value and uses an integrated value of speed error between a speed command value for the main motor and the speed of the main motor to generate a torque command value for the main motor and a torque command value for the sub motor (For example, Japanese Unexamined Patent Publication No. JP-A-2010-172054).

The integrated value of speed error between a speed command value for a main motor and the speed of the main motor may be used to generate a torque command value for the main motor and a torque command value for a sub motor. In that case, there is a problem that when the sub motor is being

2

mainly driven, in other words, when the acceleration of the main motor is negative, a position error between a position command value for the sub motor and the position of the sub motor can increase to the extent of adversely affecting the control of the motors.

An object of the present invention is to provide a motor controller capable of avoiding adverse effects of an increased position error on the control of two driven motors when any one of the two motors is mainly driven.

SUMMARY OF THE INVENTION

A motor controller according to one embodiment of the present invention is a motor controller controlling a first motor and a second motor in order to drive a single driven object. The motor controller includes a first position control unit generating a first speed command value on the basis of a position command value for the first motor, position information relating to the first motor and a first position control gain in order to control a position of the first motor, a second position control unit generating a second speed command value on the basis of a position command value for the second motor, position information relating to the second motor and a second position control gain in order to control a position of the second motor, a first speed control unit including a first integrator calculating an integrated value of a first speed error, the first speed error being a speed error between the first speed command value and a speed of the first motor, the first speed control unit generating a first torque command value on the basis of the first speed error, a predetermined value, a first proportional gain and a first integration gain in order to control the speed of the first motor, a second speed control unit including a second integrator calculating an integrated value of a second speed error, the second speed error being a speed error between the second speed command value and a speed of the second motor, the second speed control unit generating a second torque command value on the basis of the second speed error, the predetermined value, a second proportional gain and a second integration gain in order to control the speed of the second motor, an integrated value selecting unit selecting any one of the integrated value of the first speed error and the integrated value of the second speed error as the predetermined value, depending on drive status of the first motor and drive status of the second motor, a first motor driving unit driving the first motor on the basis of the first torque command value, and a second motor driving unit driving the second motor on the basis of the second torque command value.

Preferably, the integrated value selecting unit selects the integrated value of the first speed error as the predetermined value when an acceleration of the first motor exceeds a first value which is greater than zero, and selects the integrated value of the second speed error as the predetermined value when the acceleration of the first motor decreases below a second value which is smaller than zero.

Preferably, a motor controller according to another embodiment of the present invention further includes a preload torque value generating unit generating a first preload torque value and a second preload torque value such that a force applied to a drive shaft of the first motor and a force applied to a drive shaft of the second motor are in opposite directions, the first preload torque value being a torque value to be added to the first torque command value beforehand, the second preload torque value being a torque value to be added to the second torque command value beforehand.

The present invention is capable of providing a motor controller that avoids an adverse effect of an increased posi-

tion error on the control of two driven motors when any one of the two motors is mainly driven.

DESCRIPTION OF THE DRAWINGS

FIG. 1 is a block diagram of a system including a motor controller according to an embodiment of the present invention;

FIG. 2 is a diagram illustrating an example of an integrated value selecting unit and a speed control unit in FIG. 1 in detail;

FIG. 3 is a flowchart of an operation of the motor controller illustrated in FIG. 1;

FIG. 4 is a diagram illustrating an example of variations with time in acceleration of a motor controlled by the motor controller illustrated in FIG. 1;

FIG. 5A is a diagram illustrating an advantageous effect of a motor controller according to the present invention;

FIG. 5B is a diagram illustrating an advantageous effect of a motor controller according to the present invention;

FIG. 5C is a diagram illustrating an advantageous effect of a motor controller according to the present invention;

FIG. 5D is a diagram illustrating an advantageous effect of a motor controller according to the present invention; and

FIG. 6 is a diagram illustrating another example of the integrated value selecting unit and the speed control unit in FIG. 1 in detail.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

Embodiments of a motor controller according to the present invention will be described in detail with reference to drawings. Like elements are given like reference numerals throughout the drawings.

FIG. 1 is a block diagram of a system including a motor controller according to an embodiment of the present invention. The system illustrated in FIG. 1 includes a three-phase alternating-current (AC) source 1, a converter 2, a smoothing capacitor 3, inverters 4*m*, 4*s*, current detectors 5*m*, 5*s*, a main motor 6*m* which is a first motor, a sub motor 6*s* which is a second motor, transmission mechanisms 7*m*, 7*s*, a driven object 8, a machine position detector 9, motor position detectors 10*m*, 10*s*, motor speed detectors 11*m*, 11*s*, a motor controller 12 and a master controller 13.

The three-phase AC source 1 may be a commercial AC source. The converter 2 includes, for example, a plurality of rectifying diodes (six rectifying diodes in the case of three-phase AC) and transistors connected in antiparallel with the rectifying diodes, and converts AC power supplied from the three-phase AC source 1 to DC power.

The smoothing capacitor 3 is connected in parallel with the converter 2 so as to smooth a voltage rectified by the rectifying diodes of the converter 2. The inverters 4*m*, 4*s* are connected to the smoothing capacitor 3 in parallel and include, for example, a plurality of rectifying diodes (six rectifying diodes in the case of three-phase AC) and transistors connected to the rectifying diodes in antiparallel. The inverters 4*m* and 4*s* turn on and off the transistors in accordance with later-described PWM signals V_m and V_s, respectively, to convert DC power resulting from conversion by the converter 2 to AC power.

The current detector 5*m* is provided on the output line of the inverter 4*m* so as to detect a value of current I_m' flowing into the main motor 6*m*. The current detector 5*s* is provided on the output line of the inverter 4*s* so as to detect a value of current I_s' flowing into the sub motor 6*s*. In the present

embodiments, the current detectors 5*m*, 5*s* are implemented by hole elements, for example.

The main motor 6*m* includes a drive shaft acting as a master shaft coupled to the transmission mechanism 7*m* and is driven by electric power accumulated in the smoothing capacitor 3. The sub motor 6*s* includes a drive shaft acting as a slave shaft coupled to the transmission mechanism 7*s* and is driven by electric power accumulated in the smoothing capacitor 3.

In this embodiment, each of the main motor 6*m* and the sub motor 6*s* is implemented by a rotary servomotor having permanent magnets provided on one of a rotor and a stator, a linear servomotor having permanent magnets provided on one of a stator and a slider, a vibration servomotor having permanent magnets provided on one of a stator and a vibrator, an induction motor without using permanent magnets, or the like.

The transmission mechanisms 7*m*, 7*s* are connected to the driven object 8 so as to move the driven object 8 along the direction of the axis of the transmission mechanisms 7*m*, 7*s*. The driven object 8 is implemented by a machine tool table, arms of an industrial robot, or the like.

The machine position detector 9 is implemented by a scale or the like for detecting the position θx of a machine, not depicted, including the transmission mechanisms 7*m*, 7*s*, as position information relating to the first motor and position information relating to the second motor.

The motor position detector 10*m* is implemented by a rotary encoder, a hole element, a resolver or the like that detects a rotation angle $\theta m'$ of the main motor 6*m*. The motor position detector 10*s* is implemented by a rotary encoder, a hole element, a resolver or the like that detects a rotation angle $\theta s'$ of the sub motor 6*s*.

The motor speed detector 11*m* takes an input of the rotation angle $\theta m'$ of the main motor 6*m* from the motor position detector 10*m*. The motor speed detector 11*m* calculates a rotation speed $\omega m'$ of the main motor 6*m* as a speed of the first motor through first-order differentiation of the rotation angle $\theta m'$ with respect to time and outputs the rotation speed $\omega m'$ to the motor controller 12.

The motor speed detector 11*s* takes an input of the rotation angle $\theta s'$ of the sub motor 6*s* from the motor position detector 10*s*. The motor speed detector 11*s* calculates a rotation speed $\omega s'$ of the sub motor 6*s* as a speed of the second motor through first-order differentiation of the rotation angle $\theta s'$ with respect to time and outputs the rotation speed $\omega s'$ to the motor controller 12.

The motor controller 12 performs tandem control in which the driven object 8 is driven by the main motor 6*m* and the sub motor 6*s*, in order to reduce backlash between mechanical elements of the transmission mechanisms 7*m*, 7*s* and the driven object 8 and also to minimize a torsion of the drive shaft of the main motor 6*m* and a torsion of the drive shaft of the sub motor 6*s*. For that purpose, the motor controller 12 includes a subtracter 21*m*, a subtracter 21*s*, a position control unit 22*m* which is a first position control unit, a position control unit 22*s* which is a second position control unit, a subtracter 23*m*, a subtracter 23*s*, a speed control unit 24*m* which is a first speed control unit, a speed control unit 24*s* which is a second speed control unit, a motor driving unit 25*m* which is a first motor driving unit, a motor driving unit 25*s* which is a second motor driving unit, a preload torque value generating unit 26, an acceleration calculating unit 27, and an integrated value selecting unit 28.

The subtracter 21*m* includes a positive input terminal which receives a position command value θm as a position command value for the main motor 6*m*, which is the first motor, from the master controller 13, a negative input termi-

nal which receives a position θ_x from the machine position detector **9**, and an output terminal which outputs a position error $\theta_m - \theta_x$ between the position command value θ_m and the position θ_x to the position control unit **22m**.

The subtracter **21s** includes a positive input terminal which receives a position command value θ_s as a position command value for the sub motor **6s** which is the second motor, from the master controller **13**, a negative input terminal which receives a position θ_x from the machine position detector **9**, and an output terminal which outputs a position error $\theta_s - \theta_x$ between the position command value θ_s and the position θ_x to the position control unit **22s**.

The position control unit **22m** generates a speed command value ω_m for the main motor **6m** as a first speed command value on the basis of the position command value θ_m , the position θ_x , and a position control gain K_d , which is a first position control gain, in order to control the position of the main motor **6m**. For that purpose, the position control unit **22m** includes an amplifier (not depicted) for the position control gain K_d , which receives a position error $\theta_m - \theta_x$ from the subtracter **21m** and amplifies the position error $\theta_m - \theta_x$. The position control unit **22m** generates the speed command value ω_m , which is the product of the position error $\theta_m - \theta_x$ and the position control gain K_d , and outputs the generated speed command value ω_m to the subtracter **23m**.

The position control unit **22s** generates a speed command value ω_s for the sub motor **6s** as a second speed command value on the basis of the position command value θ_s , the position θ_x , and a position control gain K_d' , which is a second position control gain, in order to control the position of the sub motor **6s**. For that purpose, the position control unit **22s** includes an amplifier (not depicted) for the position control gain K_d' which receives a position error $\theta_s - \theta_x$ from the subtracter **21s** and amplifies the position error $\theta_s - \theta_x$. The position control unit **22s** generates the speed command value ω_s , which is the product of the position error $\theta_s - \theta_x$ and the position control gain K_d' and outputs the generated speed command value ω_s to the subtracter **23s**. The position control gain K_d and the position control gain K_d' may be equal to each other.

The subtracter **23m** includes a positive input terminal which receives the speed command value ω_m from the position control unit **22m**, a negative input terminal which receives the rotation speed ω_m' from the motor speed detector **11m**, and an output terminal which outputs a speed error $\omega_m - \omega_m'$ as a first speed error which is a speed error between the speed command value ω_m and the rotation speed ω_m' to the speed control unit **24m**.

The subtracter **23s** includes a positive input terminal which receives the speed command value ω_s from the position control unit **22s**, a negative input terminal which receives a rotation speed ω_s' from the motor speed detector **11s**, and an output terminal which outputs a speed error $\omega_s - \omega_s'$ as a second speed error which is a speed error between the speed command value ω_s and the rotation speed ω_s' to the speed control unit **24s**.

The speed control unit **24m** generates a torque command value T_m as a first torque command value on the basis of the speed error $\omega_m - \omega_m'$, a predetermined value which will be described later, a proportional gain K_p which is a first proportional gain, and an integration gain K_i which is a first integration gain, in order to control the speed of the main motor **6m**.

For that purpose, the speed control unit **24m** includes a first integrator, described later, into which the speed error $\omega_m - \omega_m'$ is input from the subtracter **23m** for calculating the integrated value S_m of the speed error $\omega_m - \omega_m'$, an amplifier, described

later, for a proportional gain K_p for amplifying the speed error $(\omega_m - \omega_m')$, and an amplifier, described later, for an integration gain K_i which amplifies the predetermined value mentioned above.

The speed control unit **24m** generates a torque command value T_m which is the sum of the product of the speed error $\omega_m - \omega_m'$ and the proportional gain K_p and the product of the predetermined value mentioned above and the integration gain K_i , and outputs the generated torque command value T_m to the motor driving unit **25m**.

The speed control unit **24s** generates a torque command value T_s as a second torque command value on the basis of a speed error $\omega_s - \omega_s'$, the predetermined value mentioned above and the product of a proportional gain K_p' as a second proportional gain and an integration gain K_i' as a second integration gain, in order to control the speed of the sub motor **6s**.

For that purpose, the speed control unit **24s** includes a second integrator, described later, into which the speed error $\omega_s - \omega_s'$ is input from the subtracter **23s** for calculating the integrated value S_s of the speed error $\omega_s - \omega_s'$, an amplifier, described later, for a proportional gain K_p' for amplifying the speed error $\omega_s - \omega_s'$, and an amplifier, described later, for an integration gain K_i' which amplifies the predetermined value mentioned above.

The speed control unit **24s** generates the torque command value T_s which is the sum of the product of the speed error $\omega_s - \omega_s'$ and the proportional gain K_p' and the product of the predetermined value mentioned above and the integration gain K_i' and outputs the generated torque command value T_s to the motor driving unit **25s**. The proportional gain K_p and the proportional gain K_p' may be equal to each other and the integration gain K_i and the integration gain K_i' may be equal to each other.

The motor driving unit **25m** drives the main motor **6m** on the basis of the torque command value T_m and a preload torque value $+Pr$, which will be described later. For that purpose, the motor driving unit **25m** includes an adder **41m**, a subtracter **42m** and a current control unit **43m**.

The adder **41m** includes a first positive input terminal which receives the torque command value T_m from the speed control unit **24m**, a second positive input terminal which receives the preload torque value $+Pr$ from the preload torque value generating unit **26**, and an output terminal which outputs a current command value I_m for the main motor **6m**, which corresponds to the sum of the torque command value T_m and the preload torque value $+Pr$.

The subtracter **42m** includes a positive input terminal which receives the current command value I_m from the adder **41m**, a negative input terminal which receives a current value I_m' from the current detector **5m**, and an output terminal which outputs a current error $I_m - I_m'$ between the current command value I_m and the current value I_m' to the current control unit **43m**.

The current control unit **43m** receives the current error $I_m - I_m'$ from the subtracter **42m** and generates a PWM signal V_m corresponding to a voltage command value for the main motor **6m** on the basis of the input current error $I_m - I_m'$. The current control unit **43m** outputs the generated PWM signal V_m to the inverter **4m**.

The motor driving unit **25s** drives the sub motor **6s** on the basis of a torque command value T_s and a preload torque value $-Pr$, which will be described later. For that purpose, the motor driving unit **25s** includes an adder **41s**, a subtracter **42s** and a current control unit **43s**.

The adder **41s** includes a first positive input terminal which receives the torque command value T_s from the speed control unit **24s**, a second positive input terminal which receives the

preload torque value $-Pr$ from the preload torque value generating unit **26**, and an output terminal which outputs a current command value Is for the sub motor **6s**, which corresponds to the sum of the torque command value Ts and the preload torque value $-Pr$.

The subtracter **42s** includes a positive input terminal which receives the current command value Is from the adder **41s**, a negative input terminal which receives a current value Is' from the current detector **5s**, and an output terminal which outputs a current error $Is-Is'$ between the current command value Is and the current value Is' to the current control unit **43s**.

The current control unit **43s** receives the current error $Is-Is'$ from the subtracter **42s** and generates a PWM signal Vs corresponding to a voltage command value for the sub motor **6s** on the basis of the input current error $Is-Is'$. The current control unit **43s** outputs the generated PWM signal Vs to the inverter **4s**.

The preload torque value generating unit **26** generates, in response to an excitation signal Se output from the master controller **13**, the preload torque value $+Pr$ as a first preload torque value to be added to the torque command value Tm beforehand and the preload torque value $-Pr$ as a second preload torque value to be added to the torque command value Ts beforehand such that a force applied to the drive shaft of the main motor **6m** and a force applied to the drive shaft of the sub motor **6s** are in opposite directions. The preload torque value generating unit **26** outputs the generated preload torque values $+Pr$ and $-Pr$ to the adders **41m** and **41s**, respectively.

The acceleration calculating unit **27** receives the position command value θm from the master controller **13** and calculates an acceleration a as an acceleration for the first motor through second-order differentiation of the input position command value θm with respect to time. The acceleration calculating unit **27** outputs the calculated acceleration a to the integrated value selecting unit **28**.

The integrated value selecting unit **28** selects one of the integrated values Sm and Ss as the predetermined value mentioned above, depending on the drive status of the main motor **6m** and the drive status of the sub motor **6s**.

FIG. 2 is a diagram illustrating an example of the integrated value selecting unit and the speed control unit in FIG. 1 in detail. As illustrated in FIG. 2, the speed control unit **24m** includes an integrator **31m**, which is the first integrator, an amplifier **32m**, an amplifier **33m** and an adder **34m**.

The integrator **31m** calculates an integrated value Sm . The amplifier **32m** is an amplifier for the proportional gain Kp , which amplifies the speed error $\omega m-\omega m'$. The amplifier **33m** is an amplifier for the integration gain Ki , which amplifies the predetermined value mentioned above.

The adder **34m** includes a first input terminal which receives the product of the speed error $\omega m-\omega m'$ and the proportional gain Kp from the amplifier **32m**, a second input terminal which receives the product of the predetermined value mentioned above and the integration gain Ki from the amplifier **33m**, and an output terminal which outputs a torque command value Tm which is the sum of these products.

As illustrated in FIG. 2, the speed control unit **24s** includes an integrator **31s**, which is the second integrator, an amplifier **32s**, an amplifier **33s**, and an adder **34s**.

The integrator **31s** calculates an integrated value Ss . The amplifier **32s** is an amplifier for the proportional gain Kp' , which amplifies the speed error $\omega s-\omega s'$. The amplifier **33s** is an amplifier for the integration gain Ki' , which amplifies the predetermined value mentioned above.

The adder **34s** includes a first input terminal which receives the product of the speed error $\omega s-\omega s'$ and the proportional

gain Kp' from the amplifier **32s**, a second input terminal which receives the product of the predetermined value mentioned above and the integration gain Ki' from the amplifier **33s**, and an output terminal which outputs the torque command value Ts which is the sum of these products.

As illustrated in FIG. 2, the integrated value selecting unit **28** includes a determination unit **28a** and a switch **28b**. Acceleration a is input from the acceleration calculating unit **27** into the determination unit **28a**. The determination unit **28a** determines, on the basis of the acceleration a , whether the motor controller **12** is mainly driving the main motor **6m** or mainly driving the sub motor **6s**. The determination unit **28a** provides a command that depends on the determination to the switch **28b**. The switch **28b** connects one of the output of the integrator **31m** and the output of the integrator **31s** to the input of the amplifier **33m** and the input of the amplifier **33s** in accordance with the command from the determination unit **28a**.

More specifically, when the acceleration a is kept greater than a threshold value Th' which is a second value smaller than zero ($Th'<0$) after the motor controller **12** has been set to mainly drive the main motor **6m** or after the acceleration a has exceeded a threshold value Th which is a first value greater than zero ($Th>0$), the determination unit **28a** determines that the motor controller **12** is mainly driving the main motor **6m**. On the other hand, when the acceleration a is kept smaller than the threshold value Th after the motor controller **12** has been set to mainly drive the sub motor **6s** or after the acceleration a has decreased below the threshold value Th' , the determination unit **28a** determines that the motor controller **12** is mainly driving the sub motor **6s**. The threshold value Th may be equal to the absolute value of the threshold value Th' . The use of the two threshold values Th and Th' can prevent chattering.

When the determination unit **28a** determines that the motor controller **12** is mainly driving the main motor **6m**, the determination unit **28a** controls the switch **28b** so as to connect the output of the integrator **31m** to the input of the amplifier **33m** and the input of the amplifier **33s**. Accordingly, the integrated value selecting unit **28** selects the integrated value Sm as the predetermined value mentioned above, so that the speed control unit **24m** outputs the torque command value Tm which is the sum of the product of the speed error $\omega m-\omega m'$ and the proportional gain Kp and the product of the integrated value Sm and the integration gain Ki , and the speed control unit **24s** outputs the torque command value Is which is the sum of the product of the speed error $\omega s-\omega s'$ and the proportional gain Kp' and the product of the integrated value Sm and the integration gain Ki' .

On the other hand, when the determination unit **28a** determines that the motor controller **12** is mainly driving the sub motor **6s**, the determination unit **28a** controls the switch **28b** so as to connect the output of the integrator **31s** to the input of the amplifier **33m** and the input of the amplifier **33s**. Accordingly, the integrated value selecting unit **28** selects the integrated value Ss as the predetermined value mentioned above, so that the speed control unit **24m** outputs the torque command value Tm which is the sum of the product of the speed error $\omega m-\omega m'$ and the proportional gain Kp and the product of the integrated value Ss and the integration gain Ki , and the speed control unit **24s** outputs the torque command value Ts which is the sum of the product of the speed error $\omega s-\omega s'$ and the proportional gain Kp' and the product of the integrated value Ss and the integration gain Ki' .

The master controller **13**, which is implemented by a CNC (Computer Numerical Controller) or the like, outputs the position command value θm to the subtracter **21m** and the acceleration calculating unit **27**, outputs the position com-

mand value θ_s to the subtracter **21s** and outputs the excitation signal S_e for generating the preload torque values $+Pr$ and $-Pr$ to the preload torque value generating unit **26**.

In this embodiment, the motor controller **12** is implemented by a processor including input/output ports, a serial communication circuit, an analog-digital converter, a comparator and other components, and performs various processes according to process programs stored in a memory, not depicted.

FIG. 3 is a flowchart of an operation of the motor controller illustrated in FIG. 1. First, the acceleration calculating unit **27** calculates the acceleration a and outputs the calculated acceleration a to the determination unit **28a** (step S1). Then the determination unit **28a** determines whether or not the calculated acceleration a is smaller than the threshold value Th' (step S2). When the acceleration a is smaller than the threshold value Th' , the determination unit **28a** controls the switch **28b** so as to connect the output of the integrator **31s** to the input of the amplifier **33m** and the input of the amplifier **33s** in order to select the integrated value S_s as the predetermined value mentioned above (step S3), then the process flow is terminated.

On the other hand, when the acceleration a is greater than or equal to the threshold value Th' , the determination unit **28a** determines whether or not the calculated acceleration a is greater than the threshold value Th (step S4). When the acceleration a is greater than the threshold value Th , the determination unit **28a** controls the switch **28b** so as to connect the output of the integrator **31m** to the input of the amplifier **33m** and the input of the amplifier **33s** in order to select the integrated value S_m as the predetermined value mentioned above (step S5), then the process flow is terminated. On the other hand, when the acceleration a is smaller than or equal to the threshold value Th , the process flow is terminated.

FIG. 4 is a diagram illustrating an example of variations with time in acceleration of the motor controlled by the motor controller illustrated in FIG. 1. In an operation described with reference to FIG. 4, the determination unit **28a** selects, at time t_0 which is the start of the operation, an integrated value S_s as the predetermined value mentioned above in order to set the motor controller **12** to mainly drive the main motor **6m**.

In FIG. 4, the acceleration a linearly increases from zero to a_1 ($a_1 > Th$) in the period from time t_0 to time t_1 . In the period from time t_1 to time t_2 , the acceleration a linearly decreases from a_1 to a_2 ($a_2 < a_1$). In the period from time t_2 to time t_3 , the acceleration a is maintained at a_2 (the speed of the main motor **6m** remains constant). In the period from time t_3 to time t_4 , the acceleration a linearly decreases from a_2 to the threshold value Th' . In other words, the acceleration a is kept greater than the threshold value Th' in the period from time t_0 to time t_4 after the motor controller **12** has been set to mainly drive the main motor **6m**. Accordingly, the determination unit **28a** determines that the motor controller **12** is mainly driving the main motor **6m** in the period from time t_0 to time t_4 , and selects the integrated value S_s as the predetermined value mentioned above.

In the period from time t_4 to time t_5 in FIG. 4, the acceleration a linearly decreases from the threshold value Th' to a_3 ($a_3 < Th'$). In the period from time t_5 to time t_6 , the acceleration a linearly increases from a_3 to zero. In other words, the acceleration a is kept smaller than the threshold value Th in the period from time t_4 to time t_6 after the acceleration a has decreased below the threshold value Th' . Accordingly, the determination unit **28a** determines that the motor controller **12** is mainly driving the sub motor **6s** in the period from time t_4 to time t_6 , and selects the integrated value S_s as the predetermined value mentioned above.

In the period from time t_6 to time t_7 in FIG. 4, the acceleration a is maintained at zero (the main motor **6m** is at rest). In the period from time t_7 to time t_8 , the acceleration a linearly decreases from zero to a_4 ($a_4 < a_3$). In the period from time t_8 to time t_9 , the acceleration a linearly increases from a_4 to a_5 ($Th' < a_5 < 0$). In the period from time t_9 to time t_{10} , the acceleration a is maintained at a_5 (the speed of the main motor **6m** remains constant). In the period from time t_{10} to time t_{11} , the acceleration a linearly increases from a_5 to the threshold value Th . In other words, the acceleration a is kept smaller than the threshold value Th in the period from time t_6 to time t_{11} after the motor controller **12** has been set to mainly drive the sub motor **6s**. Accordingly, the determination unit **28a** determines that the motor controller **12** is mainly driving the sub motor **6s** in the period from time t_6 to time t_{11} , and selects the integrated value S_s as the predetermined value mentioned above.

In the period from time t_{11} to time t_{12} , the acceleration a linearly increases from the threshold value Th to a_6 ($Th < a_6 < a_1$). In the period from time t_{12} to time t_{13} , the acceleration a linearly decreases from a_6 to zero. In other words, the acceleration a is kept greater than the threshold value Th' in the period from time t_{11} to time t_{13} after the acceleration a has exceeded the threshold value Th . Accordingly, the determination unit **28a** determines that the motor controller **12** is mainly driving the main motor **6m** in the period from time t_{11} to time t_{13} , and selects the integrated value S_m as the predetermined value mentioned above.

FIGS. 5A to 5D are diagrams illustrating an advantageous effect of the motor controller according to the present invention. In FIG. 5A, solid curves α and β represent variations with time in current command values I_m and I_s , respectively, that occur when an integrated value S_m is selected regardless of which of the main motor **6m** and the sub motor **6s** is being mainly driven by the motor controller **12** under the condition where the preload torque values $+Pr$, $-Pr$ are being generated. A solid curve γ in FIG. 5B represents a position error $\theta_s - \theta_m'$ corresponding to the current command values I_m and I_s represented by the solid curves α and β , respectively.

In FIG. 5C, solid curves α' and β' represent variations with time in the current command values I_m and I_s , respectively, that occur when the integrated value S_m is selected while the motor controller **12** is mainly driving the main motor **6m** and when the integrated value S_s is selected while the motor controller **12** is mainly driving the sub motor **6s**, respectively, under the condition where the preload torque values $+Pr$, $-Pr$, are being generated. In FIG. 5D, a solid curve γ' represents a position error $\theta_s - \theta_m'$ corresponding to the current command values I_m and I_s represented by solid curves α' and β' , respectively.

As represented by solid curves γ and γ' , variations in the position error $\theta_s - \theta_x$ when the integrated value S_m is selected while the motor controller **12** is mainly driving the main motor **6m** and when the integrated value S_s is selected while the motor controller **12** is mainly driving the sub motor **6s** under the condition where the preload torque values $+Pr$, $-Pr$ are being generated are much less than when the integrated value S_m is selected regardless of which of the main motor **6m** and the sub motor **6s** is being mainly driven by the motor controller **12** under the condition where the preload torque values $+Pr$, $-Pr$ are being generated.

Thus, adverse effects of an increased position error $\theta_s - \theta_x$ on the control of the main motor **6m** and the sub motor **6s** can be avoided by selecting the integrated value S_m while the motor controller **12** is mainly driving the main motor **6m** and selecting integrated value S_s while the motor controller **12** is

11

mainly driving the sub motor 6s, under the condition where the preload torque values +Pr, -Pr are being generated.

According to this embodiment, the integrated value selecting unit 28 selects one of the integrated value Sm and the integrated value Ss as the predetermined value mentioned above depending on the drive status of the main motor 6m and the drive status of the sub motor 6s. Specifically, the integrated value selecting unit 28 selects the integrated value Sm as the predetermined value mentioned above when the acceleration a exceeds the threshold value Th (the main motor 6m is mainly being driven) and selects the integrated value Ss as the predetermined value mentioned above when the acceleration a decreases below the threshold value Th' (the sub motor 6s is mainly being driven). By selecting one of the integrated value Sm and the integrated value Ss as the predetermined value mentioned above in this way, adverse effects of an increased position error $\theta_s - \theta_x$ on the control of the main motor 6m and the sub motor 6s can be avoided regardless of which of the main motor 6m and the sub motor 6s is being mainly driven while the main motor 6m and the sub motor 6s are being driven.

FIG. 6 is a diagram illustrating another example of the integrated value selecting unit and speed control unit in FIG. 1 in detail. As illustrated in FIG. 6, the integrated value selecting unit 28 includes a determination unit 28a. The determination unit 28a receives the acceleration a from an acceleration calculating unit 27 and, based on the acceleration a, determines whether the motor controller 12 is mainly driving the main motor 6m or mainly driving the sub motor 6s.

When the determination unit 28a determines that the motor controller 12 is mainly driving the main motor 6m, the determination unit 28a replaces the integrated value Ss calculated by an integrator 31s with the integrated value Sm calculated by the integrator 31m. The integrator 31s outputs the integrated value Sm, instead of the integrated value Ss, to the amplifier 33s. Accordingly, the integrated value selecting unit 28 selects the integrated value Sm as the predetermined value mentioned above, so that the speed control unit 24m outputs the torque command value Tm which is the sum of the product of the speed error $\omega_m - \omega_m'$ and the proportional gain Kp and the product of the integrated value Sm and an integration gain Ki, whereas the speed control unit 24s outputs a torque command value Ts which is the sum of the product of the speed error $\omega_s - \omega_s'$ and the proportional gain Kp' and the product of the integrated value Sm and an integration gain Ki'.

On the other hand, when the determination unit 28a determines that the motor controller 12 is mainly driving the sub motor 6s, the determination unit 28a replaces the integrated value Sm calculated by the integrator 31m with the integrated value Ss calculated by the integrator 31s. The integrator 31m outputs the integrated value Ss, instead of the integrated value Sm, to the amplifier 33m. Accordingly, the integrated value selecting unit 28 selects the integrated value Ss as the predetermined value mentioned above, so that the speed control unit 24m outputs the torque command value Tm which is the sum of the product of the speed error $\omega_m - \omega_m'$ and the proportional gain Kp and the product of the integrated value Ss and the integration gain Ki, whereas the speed control unit 24s outputs the torque command value Ts which is the sum of the product of the speed error $\omega_s - \omega_s'$ and the proportional gain Kp' and the product of the integrated value Ss and the integration gain Ki'.

The present invention is not limited to the embodiments described above and various modifications and variations are possible. For example, while a position θ_x of a machine is used as position information relating to a first motor and position information relating to a second motor in the

12

embodiments described above, a rotation angle θ_m' of a main motor 6m and a rotation angle θ_s' of a sub motor 6 may be used as the position information relating to the first motor and the position information relating to the second motor.

While a position θ_x of a machine is used to obtain a position error of the sub motor 6s in the embodiments described above, a rotation angle θ_s' of the sub motor 6s may be used to obtain the position error of the sub motor 6s.

While the above-described embodiments describe a case in which an acceleration a of the first motor is calculated by second-order differentiation of a position command value θ_m with respect to time, the acceleration a may be calculated by second-order differentiation of a rotation angle θ_m' with respect to time, or by second-order differentiation of a rotation angle θ_s' with respect to time, or by dividing the sum of the value calculated by second-order differentiation of the rotation angle θ_m' with respect to time and the value calculated by second-order differentiation of the rotation angle θ_s' with respect to time by 2.

While the embodiments have been described with examples where the preload torque value generating unit 26 is provided, the preload torque value generating unit 26 may be omitted.

What is claimed is:

1. A motor controller controlling a first motor and a second motor in order to drive a single driven object, the motor controller comprising:

a first position control unit generating a first speed command value on the basis of a position command value for the first motor, position information relating to the first motor and a first position control gain in order to control a position of the first motor;

a second position control unit generating a second speed command value on the basis of a position command value for the second motor, position information relating to the second motor and a second position control gain in order to control a position of the second motor;

a first speed control unit including a first integrator calculating an integrated value of a first speed error, the first speed error being a speed error between the first speed command value and a speed of the first motor, the first speed control unit generating a first torque command value on the basis of the first speed error, a predetermined value, a first proportional gain and a first integration gain in order to control the speed of the first motor;

a second speed control unit including a second integrator calculating an integrated value of a second speed error, the second speed error being a speed error between the second speed command value and a speed of the second motor, the second speed control unit generating a second torque command value on the basis of the second speed error, the predetermined value, a second proportional gain and a second integration gain in order to control the speed of the second motor;

an integrated value selecting unit selecting any one of the integrated value of the first speed error and the integrated value of the second speed error as the predetermined value, depending on drive status of the first motor and drive status of the second motor;

a first motor driving unit driving the first motor on the basis of the first torque command value; and
a second motor driving unit driving the second motor on the basis of the second torque command value.

2. The motor controller according to claim 1, wherein the integrated value selecting unit selects the integrated value of the first speed error as the predetermined value when an acceleration of the first motor exceeds a

first value which is greater than zero, and selects the integrated value of the second speed error as the predetermined value when the acceleration of the first motor decreases below a second value which is smaller than zero.

5

3. The motor controller according to claim 1, further comprising a preload torque value generating unit generating a first preload torque value and a second preload torque value such that a force applied to a drive shaft of the first motor and a force applied to a drive shaft of the second motor are in opposite directions, the first preload torque value being a torque value to be added to the first torque command value beforehand, the second preload torque value being a torque value to be added to the second torque command value beforehand.

10
15

* * * * *